

DEPARTMENT OF TRANSPORTATION

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch

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Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 70.28**WELDING INSPECTION REPORT****Resident Engineer:**Pursell, Gary**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-006231**Date Inspected:** 11-Apr-2009**Project Name:** SAS Superstructure**OSM Arrival Time:** 730**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1530**Contractor:** Japan Steel Works**Location:** Muroran, Japan**CWI Name:** Chung Fu Kuan**CWI Present:** Yes No**Inspected CWI report:** Yes No N/A**Rod Oven in Use:** Yes No N/A**Electrode to specification:** Yes No N/A**Weld Procedures Followed:** Yes No N/A**Qualified Welders:** Yes No N/A**Verified Joint Fit-up:** Yes No N/A**Approved Drawings:** Yes No N/A**Approved WPS:** Yes No N/A**Delayed / Cancelled:** Yes No N/A**Bridge No:** 34-0006**Component:** Tower, Jacking and Deviation Saddles**Summary of Items Observed:**

On this date, 4/11/09, Caltrans OSM Quality Assurance (QA) Inspector Mike Brcic was present during the times noted above for observations relative to the work being performed on castings, in the Fabrication shop #4.at Japan Steel Works.

W2E1 - Section is moved in to Machine Shop #2 for removal of lifting lugs.

W2E3 - Scheduled work ceased due to maintenance on overhead crane (above casting).

W2W1 - Verified condition of casting while stored at wharf laydown yard. Built up section effected by crane maintenance also.

W2W2 - Cast awaiting NDE; Built up portion also sits beneath crane, no access to area.

T1-2 - Welders 08-5153 and 08-5018 are FCAW welding per SJ3012-5 on joints 8Y-12U-1 and 8Y-12U-3 respectively both providing cap pass to complete all welding to this side, saddle will require to be turned over for weld to continue. Witnessed QC Inspector verify and all pertinent parameters were met.

T1-3 - All mating surfaces of casting have now been buttered, now buttering is complete on 3 of 4 locations of lifting lugs, no one in work at this time.

Unless otherwise noted, all observations reported on this date appeared to be in general compliance with applicable contract documents.

Summary of Conversations:

No significant conversations to report on this day.

WELDING INSPECTION REPORT

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Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Nina Choy, 1(510)385-5910, who represents the Office of Structural Materials for your project.

Inspected By:	Brcic,Michael	Quality Assurance Inspector
Reviewed By:	Lanz,Joe	QA Reviewer
